

Split w/o 180303.31






DART AEROSPACE LTD		Work Order:	18901 A
Description: Bracket		Part Number:	D3145-1
Dwg: D3145 Rev. B		Qty:	61028
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	H	03.03.05	6102
2	MV	Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2.000x2.000 Batch: M12925	SL	07/03/06	102
3	MV	Machine per Folio FA318 and Dwg D3145	E	03.03.31	2
4	QC2	Inspect parts as they come off the CNC machine	E	03.03.31	2
5	MV	Deburr and Tumble	E	03.03.31	2
6	QC5	Second inspection	18030331	2	
7	FP	Chemical Conversion Coat per QSI 005 4.1	2	03.03.31	2
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	2	03.03.31	2
9	QC3	Inspect work to Step 8	M	03.03.31	2
10	ST	Identify and Stock	4	03.03.31	2
11	AC	Cost / part 166.46	SAC	03/04/01	2
12	DC	Close W/O 166.42 Inspect Level 21	A	03.04.01	-

Rev	Date	Change	Revised By	Approved
A	03.02.28	New issue	KJ/RF	

RELEASED
03.03.04 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					
03.03.28	3	End slot offsetted one side 0.035" Qty 1 part affected (fai)		Increase slot length by 0.035" in opposite direction	 03.03.31	 03.03.31	 03.03.28	 03.03.31

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

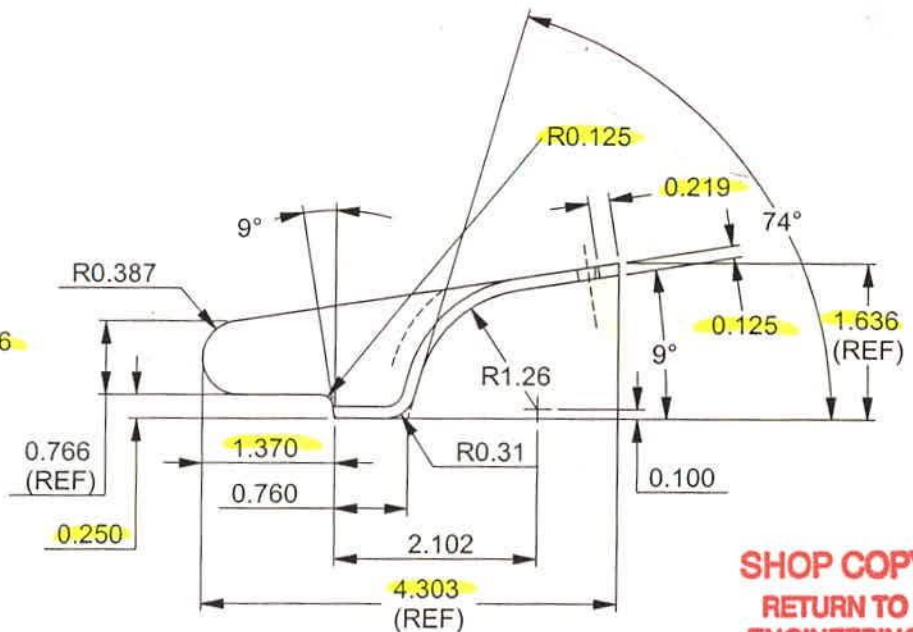
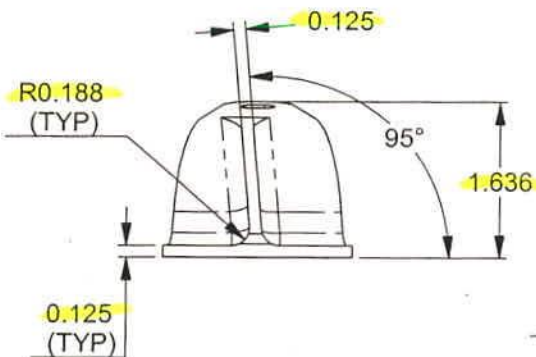
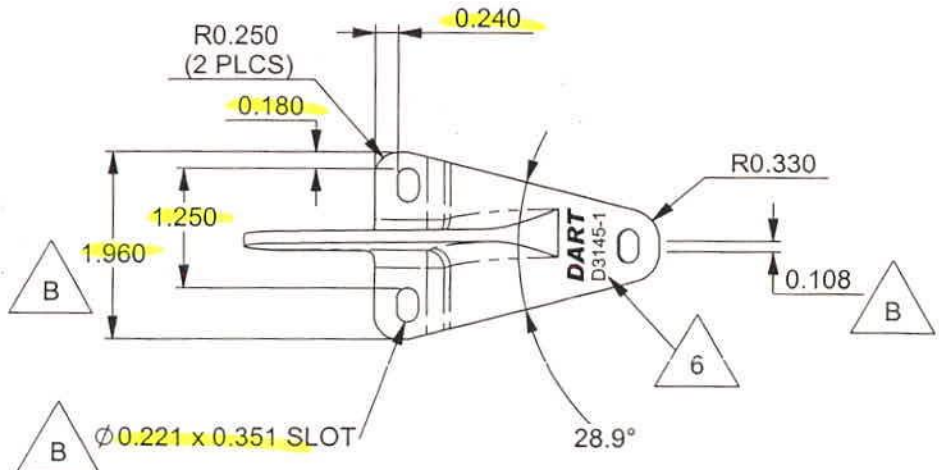
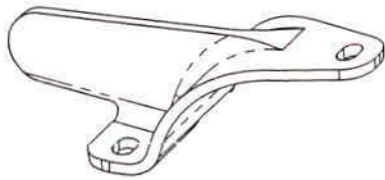
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

**PRELIMINARY
ISSUE**



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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**WORK ORDER
NO. 18901**

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 05, 2003
10:56 am

Work Order No : 0018901 **A**
Project Name : D3145-1
Project For : WK312
Work Order Type : Main
Main WO Number :
House Part Number : D3145-1
Description : Bracket
Manufactured : Yes
Amount Req'd : **6 12 2**
Amount Done : 0
Start Date : 03-05-03
Est Finish Date : 03-27-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Dart Aerospace, Ltd

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet ____ of ____

INSPECTION CHECKLIST

PART NO.: D3145-1

PHY. CHANGE: _____

DESCRIPTION: Bracket

DRAWING CHANGE: _____

MANUFACTURING DATE: 03.03.26

UNICORP E.O.'S: _____

BATCH NO.: 18901

SERIAL NO.: _____

PURCHASE ORDER NO.: _____

QUANTITY ACPT. _____ REJ. _____

DATA SHEET NO.: _____

☒ FIRST ARTICLE ☐ PERIODIC CONFORMITY ☐ FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1		1.960	±0.01	1.960	✓				
		1.250	"	1.252	✓				
		0.180	"	0.178	✓				
		0.240	"	0.236	✓				
		φ0.221 x 0.351	"	φ0.234 x 0.359		✓	OK # 03.03.31		
		R0.188	±0.010	R.1875	✓				FIXED IN ITEM # 1 # 03.03.31
		0.125	"	0.127	✓				
		1.636	"	1.629	✓				
		0.125	"	0.116	✓				
		0.250	±0.01	0.257	✓				
		1.370	"	1.350		✓	OK # 03.03.31		
		4.303	"	4.300	✓				
		R.125	"	R.125					
		0.219	"	0.200		✓	OK # 03.03.31		
		0.125	"	0.121	✓				
		1.636	"	1.629	✓				
		φ0.221 x 0.351	"	φ.233 x 0.359		✓	OK # 03.03.31		
<hr/>									
2		φ.221 x 0.351	±0.01	φ.226 x 0.378	✓				
		1.370	"	1.361	✓				
		0.219	"	0.226	✓				

H:\admin-qaliso\forms\first article inspectionA

Rev. B

Measured by: BE

Audited by: [Signature]

Approved by: [Signature] 03.03.31